Work Order ID 70490 RH

Thursday, June 09, 2011 3:19:19 PM

Item ID: D206-642-151 Right Hand

Revision ID:

Item Name: Replacement Skidtube

Accept **Setup Start** **Stop**

Start Date: 6/9/2011 **Start Qty:** 1.00

Required Date: 6/20/2011 **Req'd Qty:** 1.00

Reference:

Cust Item ID:

Customer:

Approvals: **Process Plan:** M **Date:** 11-069 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D3804	A
IIN-D206-642	N

100 0.00

DC DOCUMENT CONTROL

N/A

Document Control **Memo** 0.00

Photocopy bluefile & type labels per PPP D206-642-151 CHG001

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Work Order ID 70490

Thursday, June 09, 2011 3:19:19 PM

Item ID: D206-642-151 **Accept** **Setup Start**

Revision ID: **Stop**

Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Start Qty:** 1.00 **Cust Item ID:**

Required Date: 6/20/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

Skidtubes

1-Deburr Fwd edge of tube 3 DL. 11/07/07

2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804

3-Weld Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.
Pick:
Qty ☐Part Number☐ Description☐Batch
A/R☐☐ Aluminum Rod☐ M112800 M115778 BE 11/07/07 BE 11/07/07

4-Grind weld flush to cap on top surface only.

5-Cut Aft end as per dwg D3804 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D3804

7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025. DL. 11/07/07

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. BE 11/07/K

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

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Start Date: 6/9/2011 **Start Qty:** 1.00 **Cust Item ID:**

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.								
	12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D3804								
	13-Remove D3286-1 doubers, identify orientation, deburr, then attach them to the workorder								
	14-Remove indexing edge using DT8741 as per Dwg D3804								
	15-C'sink GHW rivet holes as per Dwg D3804								
	16- Open Aft cap hole #6. ****no wearplate holes for this skidtube****								
	17-Deburr tube and blow out chips from inside the tube								
120 QC Quality Control	QC6- Inspect dimensions to drawing	0.00							
	Memo	0.00							

BE 11/07/11

8 11/07/11

H

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Start Qty:** 1.00 **Cust Item ID:**

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Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00				1			11/07/14
HandFinish	**Memo**	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00				1	0		11/07/14
QC	**Memo**	0.00							
Quality Control									
160		0.00				1	0		11/09/12
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							
	1-Open holes to finished size as per Dwg D3804, (without cutting fluid)								
	2-C'sink crossbolt spacer holes as per Dwg D3804(without cutting fluid)								
	3-Deburr and blow out all chips from inside the tube								

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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NOTE: Date & initial all entries

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Item ID: D206-642-151 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Replacement Skidtube

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Required Date: 6/20/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC6- Inspect dimensions to drawing	0.00							
QC	**Memo**	0.00 S 11/09/13							
Quality Control									
180		0.00							
Skidtubes	Skidtubes								
Skidtubes	**Memo**	0.00							

1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required

D2654-1

2-Bond ~~D2654-3~~ web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting

Start Date:☐ 11/09/13 ☐Time:☐ 3:30 ☐

Finish Date:☐ 11/04/16 ☐Time:☐ 9:00

Pick:

Qty ☐Part Number☐Description☐Batch

A/R☐☐Sikaflex-291☐ 1183913 ☐☐

Sikaflex expire date:☐ 12/04/05

BE 11/09/13

Pto→

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W/O: 70490		WORK ORDER CHANGES						
DATE	**STEP**	Perm. Change **PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector	
11/7/14	# 180-2	Fix comment to READ the correct web to pull. not D2654-3 should BE D2654-1	[illegible]	11.10.06	N/A	[illegible]	[illegible] 11/07/14	

Part No: D206-642-151 **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Required Date: 6/20/2011 **Req'd Qty:** 1.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00 Sulo2/15							
Quality Control									

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W/O:		WORK ORDER CHANGES					
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Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Skidtubes	0.00							
Skidtubes	**Memo**	0.00							

Skidtubes

1-remove alodine from around hole and prepare for welding BE 11/09/16

2-Prep per QSI 005 and Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
Pick:
Qty☐Part Number☐Description☐Batch
A/R☐☐Aluminum Rod☐ 1M12860 BE 11/09/16

3-Grind welds flush as per Dwg D3804. DL 11/09/20

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required.
A/R☐SS Rod☐ NONE BE 11/09/21

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D3804. Deburr DP 11-9-22

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	HandFinishing	0.00							
HandFinish									
Hand Finishing	**Memo** Install D2680-041 Nut Plate as per Dwg D3804	0.00							
220	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC									
Quality Control	**Memo**	0.00							
	QC10 →								
230	QC5- Inspect part completeness to step on W/O	0.00							
QC									
Quality Control	**Memo**	0.00							

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	Pressure Wash per QSI005 4.3	0.00				1	BL	11-9-29	
HandFinish	**Memo**	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 1:00 OVEN TEMPERATURE: ~~320~~ 0 F FINISH TIME: ~~1:30~~								
260	QC3- Inspect Part Finish	0.00							
QC	**Memo**	0.00							
Quality Control									

MN118439

~~XX~~ M-L 11/04/29

1 ϕ N 11/10/04

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

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Item ID: D206-642-151 **Accept** **Setup Start** **Stop**

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HandFinishing	0.00				1	0		11/10/04
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive.								
280	HandFinishing	0.00				1	0		11/10/04
HandFinish	**Memo**	0.00							
Hand Finishing	1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R☐☐Sikaflex-291☐ M1103475☐☐ Sikaflex expire date:☐ 12/05								
	2- Install wearplate as per dwg								
	2-Wing Walk as per Dwg D3804 and QSI 005 4.4☐ Batch: M1103B								

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Run Start

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290 QC Quality Control	QC3- Inspect Part Finish **Memo**	0.00 0.00							
300 QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00							
310 Packaging Packaging	Packaging **Memo** Identify and pack for shipping as per PPP D206-642-151 Location:_____ PPP Rev:_____	0.00 0.00		74378		11/10/05			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
320	QC21- Final Inspection - Work Order Release	0.00					11	10	6
QC	**Memo**	0.00							
Quality Control									

MF
11-10-06

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, June 09, 2011 3:19:26 PM

Work Order ID: 70490

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP REV:A 10.12.08 PER IIN REV.N DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2620		Manufactured	No				Each	12.0000		1			
Skidtube, 206 Skidtube												11/07/07	
				Location			**Loc Qty**		**Loc Code**				
				LG	B7/6/6		12			1			
					62684		1						
					68135		1						
					68136		10						
D3286-1		Manufactured	No				Each	36.0000		2			
Doubler												8E11/07/11	
				Location			**Loc Qty**		**Loc Code**				
				LG002			36						
					52844		15			2			
					64563		21						
D2647		Manufactured	No				Each	30.0000		1			
Cap												8E11/07/07	
				Location			**Loc Qty**		**Loc Code**				
				LG002			30						
					55352		30			1			

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DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Thursday, June 09, 2011 3:19:26 PM

Work Order ID: 70490

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

CR3212-4-04	Purchased	No		Each	678.0000	52

Cherry Rivet

BE 11/09/13

Location	Loc Qty	Loc Code	
ST311	678		
115698	39		
116471	139		
117816	500		52

D2654-1	Manufactured	No		Each	0.0000	1

Web

BE 11/09/13

B 64562 ~1

D2649	Manufactured	No		Each	207.0000	19

Cross Bolt Spacer

BE 11/09/16

B 73390 ~19

Location	Loc Qty	Loc Code	
LG	195		
68224	40		
70394	155		
LG001	12		
65317	1		
68507	11		

D3286-3	Manufactured	No		Each	31.0000	2

Spacer

BE 11/09/11

Location	Loc Qty	Loc Code	
LG002	31		
46643	1		
64564	30		2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Thursday, June 09, 2011 3:19:26 PM

Work Order ID: 70490

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

CCR264SS3-3	Purchased	No		Each	581.0000	2

Cherry Rivet

Location	Loc Qty	Loc Code
FP-B	2	
113973	2	
ST311	579	
117086	79	
117849	500	

CR3212-4-03	Purchased	No		Each	1,228.000	2

Cherry Rivet

Location	Loc Qty	Loc Code
FP-B	2	
110139	2	
ST311	1226	
114859	1226	

D2680-041	Manufactured	No		Each	36.0000	1

Nut Plate

Location	Loc Qty	Loc Code
ST020 73334	36	
55366	17	
70088	19	

D3805-041	Manufactured	No		Each	2.0000	1

Wearplate Assembly Fwd, Low Gear

Location	Loc Qty	Loc Code
FP	2	
64565	2	

B73813

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID: 70490

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3805-045 Manufactured No Each 2.0000 1

Wearplate Assembly Aft, Low Gear

B70878 (x1) 11/10/05

Location	Loc Qty	Loc Code	
FP	2		
64566	2		

AN3-37A Purchased No Each 255.0000 7

Bolt

11/10/04

Location	Loc Qty	Loc Code	
ST353	205		
105425	69		
111668	136		x 7
ST354	50		
117619	50		

AN960JD10 NAS1149D0363J Purchased No Each 0.0000 7

Washer

~~M118077~~ M118077 (x7) 11/10/04

MS21042L3 Purchased No Each 2,322.000 7

Nut

11/10/04

Location	Loc Qty	Loc Code	
ST300	2322		
116391	9		
116549	613		
117441	800	M118451	x7
117601	400		
117885	500		

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W/O:		WORK ORDER CHANGES					
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Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

D3873-1	Manufactured	No		Each	112.0000	14

Bushing

Location	Loc Qty	Loc Code
ST084	100	B71837
68247	100	
ST088	12	B370690
64760	12	

AN960JD416 NAS1149D0463J	Purchased	No		Each	0.0000	1

Washer

D2651-1	Manufactured	No		Each	248.0000	6

Plug

Location	Loc Qty	Loc Code
fpa	121	
69018	121	
FP-A	127	
57869	7	
66445	10	
67263	12	
67760	98	

D2651-3	Manufactured	No		Each	576.0000	6

O-Ring

Location	Loc Qty	Loc Code
FP-A	576	
61962	132	
66956	444	

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Work Order ID: 70490

Parent Item: D206-642-151

Parent Item Name: Replacement Skidtube

Start Date: 6/9/2011 **Required Date:** 6/20/2011

Start Qty: 1.00 **Required Qty:** 1.00

MS27039-4-06 Purchased No Each 61.0000 1

Screw

Location	Loc Qty	Loc Code
FP-A	26	
115460	26	
ST292	35	
115460	35	

D2646 Manufactured No Each 24.0000 1

Aft Cap

Location	Loc Qty	Loc Code
FP006	23	
62678	23	B71070
FP-4	1	
69019	1	

MS27039-1-08 Purchased No Each 768.0000 2

Screw

Location	Loc Qty	Loc Code
ST291	768	AA118378
115108	468	
117423	300	

AN960JD10L NAS1149D0332J Purchased No Each 0.0000 2

Washer

AA117087

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W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR264SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

1) MATERIAL: N/A
2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 -POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
7) IDENTIFICATION: NONE
8) WEIGHT: 12.5 lb
9) WELD PER DART QSI 004
10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
 THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70490

11-069

RELEASED
09.03.03
per ECN 09-536

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	MB	08.07.07

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

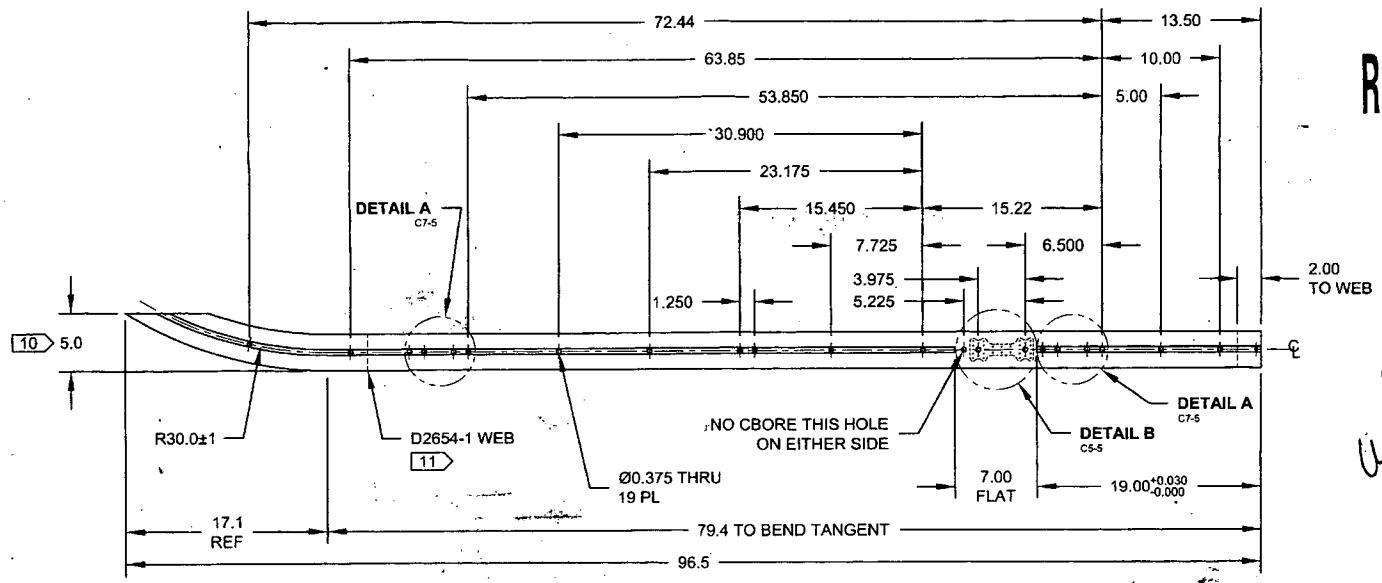
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

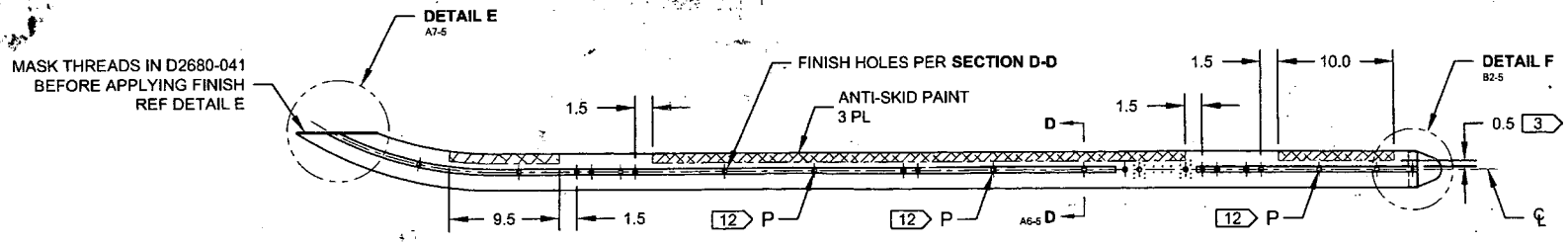
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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

RELEASED
09.03.03



D3804-041 BENDING/DRILLING DETAIL



D3804-041 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
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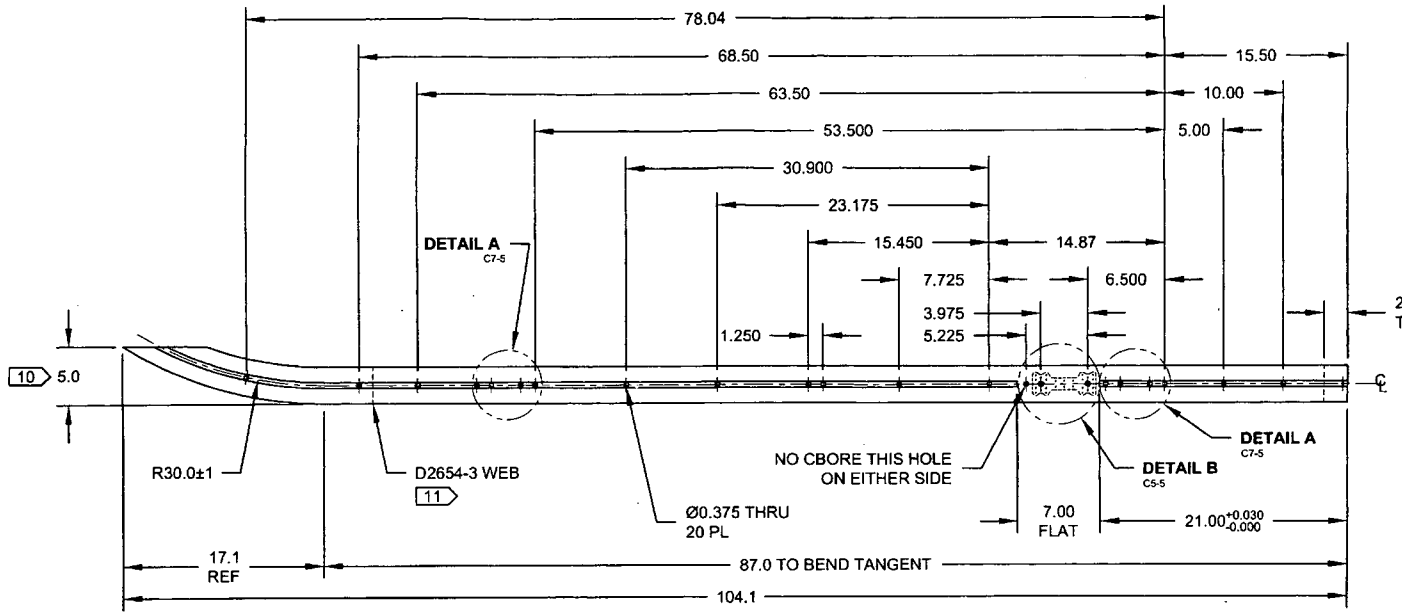
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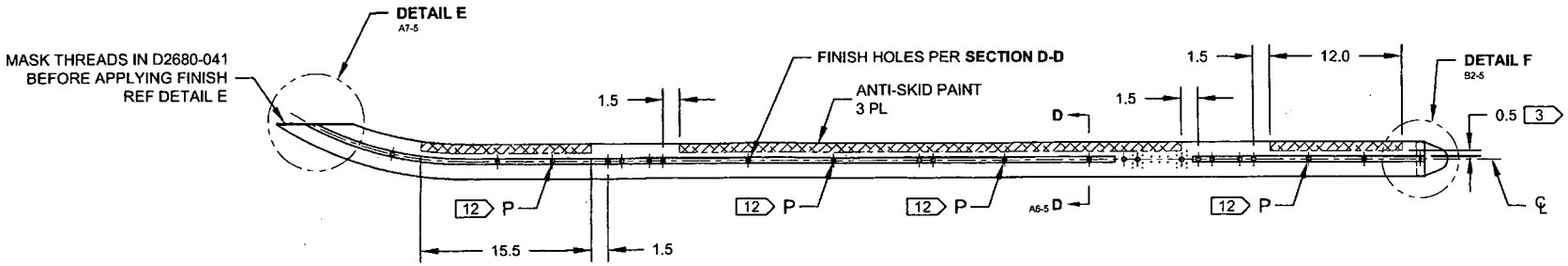
NOTE: Date & initial all entries

RELEASED
09.03.07

wb 70490



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN		DART AEROSPACE USA, INC PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3804 SHEET 3 OF 5
APPROVED		TITLE SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B NTS
DATE	08.07.07	

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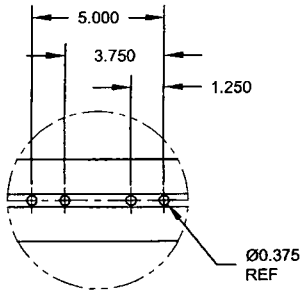
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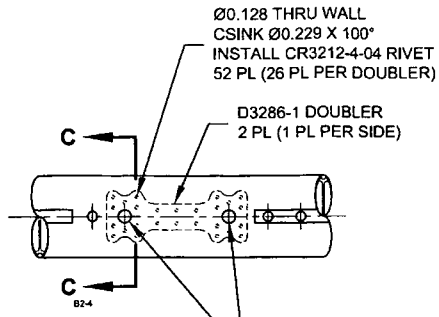
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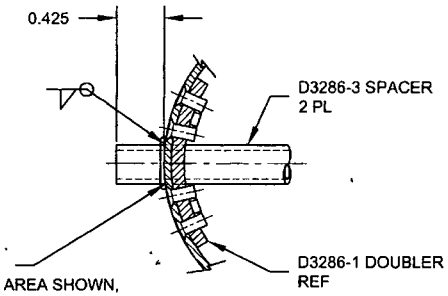
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DETAIL A D6-2 C2-2 D6-3 C2-3
SCALE NONE

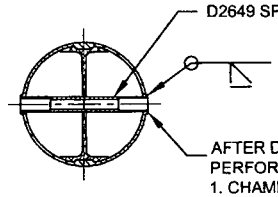


DETAIL B C3-2 C3-3
SCALE NONE



TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
3. ENLARGE HOLES IN D3286-1 TO Ø0.500
4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
5. RIVET D3286-1 TO TUBE
6. INSERT D3286-3 SPACER
7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

SECTION D-D A4-2 A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

DESIGN		**DART AEROSPACE USA, INC** PORT HADLOCK, WA
DRAWN		
CHECKED		DRAWING NO. D3804 REV. A SHEET 4 OF 5
MFG. APPR.		
APPROVED		TITLE SKIDTUBE ASSEMBLY, 206A/B SCALE NTS
DE APPR.		
DATE 08.07.07		

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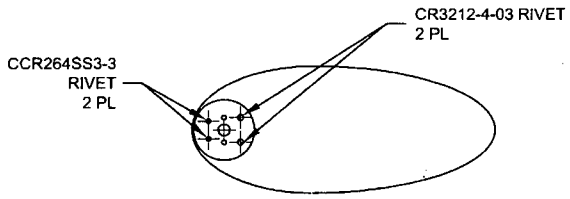
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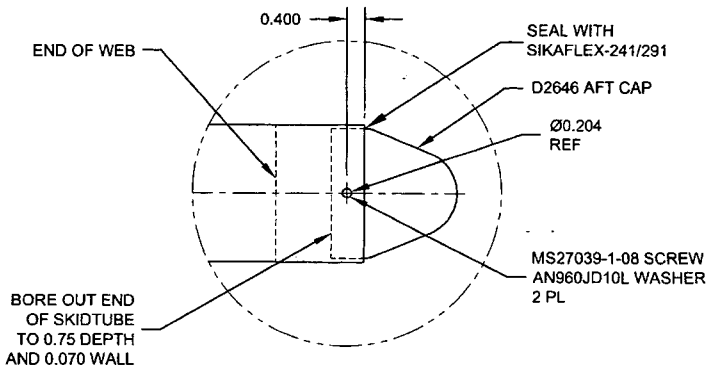
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09.03.07

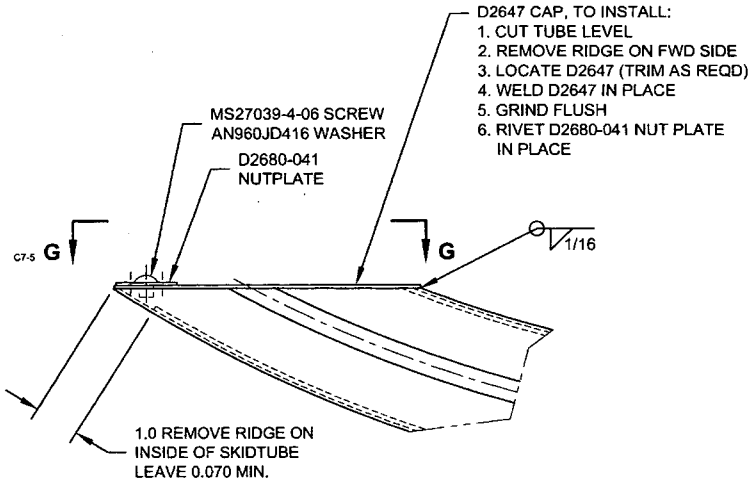


VIEW G-G
SCALE NONE A7-5

w/ 70490



DETAIL F
SCALE NONE B2-2 B2-3



DETAIL E
SCALE NONE B7-2 B7-3

DESIGN		DART AEROSPACE USA, INC	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3804	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07		

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

NO. 266

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 704089
Part number: 5206 642 151
Description: 206
Welding Process: Tig[√] Mig[]
Base materiel: Aluminum
Current: AC[√] DC[]

TEST REQUIREMENTS AND RESULTS

Visual:	pass[√]	fail[]
Penetration:	pass[√]	fail[]

UNACCEPTABLE

Cracks:	pass[√]	fail[]
Undercut:	pass[√]	fail[]
Pin holes:	pass[√]	fail[]
Overlap (cold lap)	pass[√]	fail[]
Porosity (surface):	pass[√]	fail[]
Coloration:	pass[√]	fail[]

Qualifier Jody Lyons **Date of Test Coupon** 11.09.22

Welder Barclay Elliott **Date of Test Coupon** 11-09-22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld